

Work Order ID 63056

Tuesday, October 19, 2010 10:35:11 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 10-10-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop:



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

n/A ckt 10/11/03 [Signature]

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

[Signature]

10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Deburr ends and remove marks bending marks

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

(X1)

BB 10/19/20

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

1 - JE 10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M115778

BE 10/10/21

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M115778

BE 10/10/21

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/10/27

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Cust Item ID:

Required Date: 11/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/10/27

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/10/27

Quality Control

⑦

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

① 8/10-10-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 10/19/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 11/5/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115291.</i> Memo START TIME: <i>9:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:45</i>	0.00 0.00				<i>①</i>		<i>31 10/10/28.</i>	
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>=> 11 10/10/28</i>		<i>1</i>	<i>0</i>		

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Required Date: 11/5/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPN 61729

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(70)

10/11/03 (1)

10/11/03
MF
10-11-3

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Picklist Print

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Page 1

Work Order ID: 63056

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 10/19/2010

Required Date: 11/5/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N02.08.280FP was QC5 in Step 27; Added QC5 to Step 300KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1

Manufactured

No

110

Each

3.0000

1

1



205 Skidtube bent detail

Location

Loc Qty

Loc Code

LG

B62353

2

62047

1

62048

1

ST046

1

59856

1

①

DP 10-10-19

D2576-3

Manufactured

No

140

Each

68.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

68

46661

20

52215

48

BE 10-10-21

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/19/2010

Required Date: 11/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 144.0000 20 20



Crossbolt Spacer

Location Loc Qty Loc Code

LG 144
57052 5
57348 4
58433 2
59113 7
60845 1
61199 125

D2855 Manufactured No 200 Each 55.0000 1



Cap

Location Loc Qty Loc Code

FP6 1
56613 1
ST026 54
50513 1
50770 28
51539 2
53791 23

AN3-5A Purchased No 200 Each 1,445.000 2



Bolt

Location Loc Qty Loc Code

ST350 1445
105057 445
115016 500
115371 500

20 BE 10/10/28

10/10/28

x1

2

10/10/28

v2

Tuesday, October 19, 2010 10:35:16 AM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 63056

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/19/2010

Required Date: 11/5/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No



Washer

ALS7-1032-130 Purchased No



Insert

200 Each 0.0000 2 2

M114348



x2 JH 10/10/28

200 Each 1,706.000 50 50



JH 10/10/28

Location

Loc Qty

Loc Code

FP 115079

689 689

M115911

x50

ST282

1017

113238

17

115502

500

115581

500

AN3C4A Purchased No



BOLT

200 Each 1,361.000 50 50



JH 10/10/28

Location

Loc Qty

Loc Code

ST303

3

115438

3

ST350

1358

114108

14

114416

12

114523

2

115300

330

115589

1000

x50

AN960C10L NAS1149C0332 Purchased No



washer

200 Each 29.0000 50 50



JH 10/10/28

Location

Loc Qty

Loc Code

ST245

29

107534

29

M115832

x50

Tuesday, October 19, 2010 10:35:16 AM

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Page 3

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Page 4

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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 10/19/2010



Required Date: 11/5/2010

Start Qty: 1.00



Required Qty: 1.00

D3566-13 Manufactured No 200 Each 31.0000 1 1
  yl 10/10/28
 Gasket



Location	Loc Qty	Loc Code
FP012	31	
60209	6	
61996	25	

D3566-5 Manufactured No 200 Each 17.0000 1 1
  yl 10/10/28
 Gasket

Location	Loc Qty	Loc Code
FP	5	
60869	5	
FP015	12	
62463	12	

D3566-1 Manufactured No 200 Each 3.0000 2 2
  yl 10/10/28
 Gasket

Location	Loc Qty	Loc Code
FP015	3	
57715	2	362892
61992	1	

D3564-11 Manufactured No 200 Each 9.0000 1 1
  yl 10/10/28
 Wearshoe

Location	Loc Qty	Loc Code
FP019	9	
61708	9	

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Page 4

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Page 5

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Parent Item Name: Replacement Skidtube

Start Date: 10/19/2010

Required Date: 11/5/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

31.0000

1

1



Wearshoe



HL 10/10/28

Location

Loc Qty

Loc Code

FP17

31

59660

1

60862

8

61828

10

62229

12

VI

D3564-9

Manufactured No

200

Each

14.0000

1

1



Wearshoe



HL 10/10/28

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

13

61709

13

VI

D3564-5

Manufactured No

200

Each

19.0000

1

1



Wearshoe



HL 10/10/28

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

5

57525

1

58709

1

61699

3

VI

FP-19

13

62237

13

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Page 5

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Parent Item Name: Replacement Skidtube

Start Date: 10/19/2010

Required Date: 11/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

883.0000

16

16



O-Ring, 205 Skidtube



10/11/02

Location

Loc Qty

Loc Code

FP

43

55546

19

58191

12

59358

12

fpa

840

61762

840

X16

D2594-1

Manufactured No

200

Each

219.0000

16

16



Plug, 205 Skidtube



10/11/02

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

1362893

X16

FP14

36

58434

15

61932

21

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *13056*

08/10-10-19

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 240

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 62176
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. P. Date of Test Coupon 10.09.30
Welder Barday Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld